Date: Wednesday, 3/7/2007 4:08:27 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET LH/RH 350/355
Job Number	: 31087		
Estimate Number	: 10211		
P.O. Number	: N/A	Part Number	: D350607045
This Issue	: 3/7/2007 S.O. No. : N/A	Drawing Number	: D350-607 PG7-9
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: F
Previous Run	: 29129	Material	: N/A
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.03.07		
Comment	: Est Rev:C as per DSI9318 06-01-24 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPPD350-607-045 CHG001	09/10
2.0	31087A	350 BASKET BASE (SHORT)
	Comment: Sub-Component 350 BASKET BASE (SHORT) D3265-041 B 31087A	SAD 07/09/06 (1)
3.0	31087B	350 BASKET LID (SHORT)
	Comment: Sub-Component 350 BASKET LID (SHORT) D3266-041 B 31087B	SAD 07/09/06 (1)
4.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick: Assemby Kit	
5.0	D2022101	Spacer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 2 D2022-101 Spacer B30543	

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31087 **Part Number:** D350607045

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	D2258200	Weight Placard 200lb

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2258-200 Label B32276

Seq. #:	Machine Or Operation:	Description :
7.0	D2332041	Lid Prop Assembly 6.69"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2332-041 Prop Ass'y B32572

Seq. #:	Machine Or Operation:	Description :
8.0	D2530	Handle Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2530 Handle Weldment B32573

Seq. #:	Machine Or Operation:	Description :
9.0	D2535	Spring

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2535 Spring B31486

Seq. #:	Machine Or Operation:	Description :
10.0	D2537	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2537 Bushing B32574

Seq. #:	Machine Or Operation:	Description :
11.0	D27283	Dart Logo label large

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2728-3 Label B22553

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:08:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31087 **Part Number:** D350607045

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	D2931	Bumper

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2931	Bumper	21139

Seq. #:	Machine Or Operation:	Description :
13.0	AN316A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN3-16A	Bolt	M104093

Seq. #:	Machine Or Operation:	Description :
14.0	AN47A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN4-7A	Bolt	M102140

Seq. #:	Machine Or Operation:	Description :
15.0	AN422A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	AN4-22A	Bolt	M102959

Seq. #:	Machine Or Operation:	Description :
16.0	AN424A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	AN4-24A	Bolt	M101938

Seq. #:	Machine Or Operation:	Description :
17.0	AN517A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
4	AN5-17A	Bolt	M104885

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 31087
Part Number: D350607045

Job Number:

Seq. #:	Machine Or Operation:	Description :
18.0	AN960JD8	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD8 Washer M104374

Seq. #:	Machine Or Operation:	Description :
19.0	AN960JD416	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD416 Washer M104215

Seq. #:	Machine Or Operation:	Description :
20.0	AN960JD416L	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD416L Washer M105078

Seq. #:	Machine Or Operation:	Description :
21.0	AN960JD516	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M104156

Seq. #:	Machine Or Operation:	Description :
22.0	AN9704	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN970-4 Washer M103344

Seq. #:	Machine Or Operation:	Description :
23.0	MS20600AD4W3	Cherry Rivets

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS20600AD4W3 Rivet M104715

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31087 **Part Number:** D350607045

Job Number:

Seq. #:	Machine Or Operation:	Description :
24.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) M 104936

Seq. #:	Machine Or Operation:	Description :
25.0	MS21042L4	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L4 Nut (or -4) M104248

Seq. #:	Machine Or Operation:	Description :
26.0	MS21042L5	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L5 Nut (or -5) M104547 7/9/6 (1)

Seq. #:	Machine Or Operation:	Description :
27.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D350-607 SAD 07/09/04

Seq. #:	Machine Or Operation:	Description :
28.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 7/09/06

Seq. #:	Machine Or Operation:	Description :
29.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Packing Kit

Seq. #:	Machine Or Operation:	Description :
30.0	D22301	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2230-1 Lug B32163

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 31087
Part Number: D350607045

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	D22303	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2230-3 Clamp B30993

32.0	D23241	Strut Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 *D2324-1 Strut Ass'y B32278

33.0	D2856400	Abrasion Strip

Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 D2856-400-720 Abrasion Strip B32992

34.0	AN412A	Bolt

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
5 AN4-12A Bolt M104547

35.0	AN413A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 AN4-13A Bolt M104746

36.0	AN960JD416	Washer

Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
26 AN960JD416 Washer M104746

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes / No (circled: No) **DQA:** [illegible] **Date:** 07/09/11

QA: N/C Closed: _____ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:08:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31087 **Part Number:** D350607045

Job Number:

Seq. #:	Machine Or Operation:	Description :
37.0	MS21042L4	Nut

Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
13 MS21042L4 Nut (or -4) M104248 8X M103914 1X M102552 4X 07/9/6 (1)

Seq. #:	Machine Or Operation:	Description :
38.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS 07/09/10 (TL)

Seq. #:	Machine Or Operation:	Description :
39.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-607-043
Location: REV: A 07/9/10 (1)

Seq. #:	Machine Or Operation:	Description :
40.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE (1) 07/09/11

Job Completion

07-09-11

Form: process

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

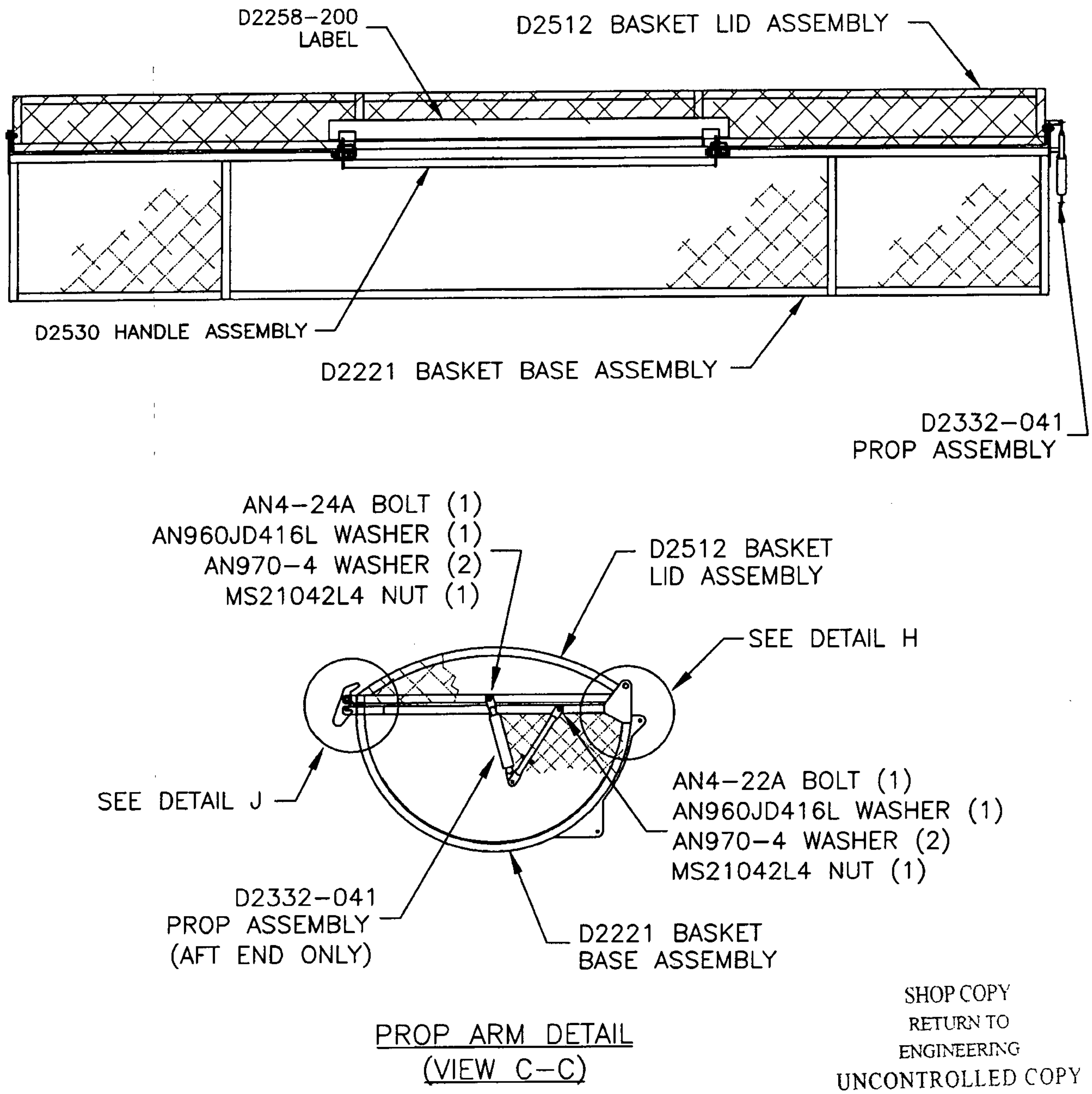


Figure 4 – Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)

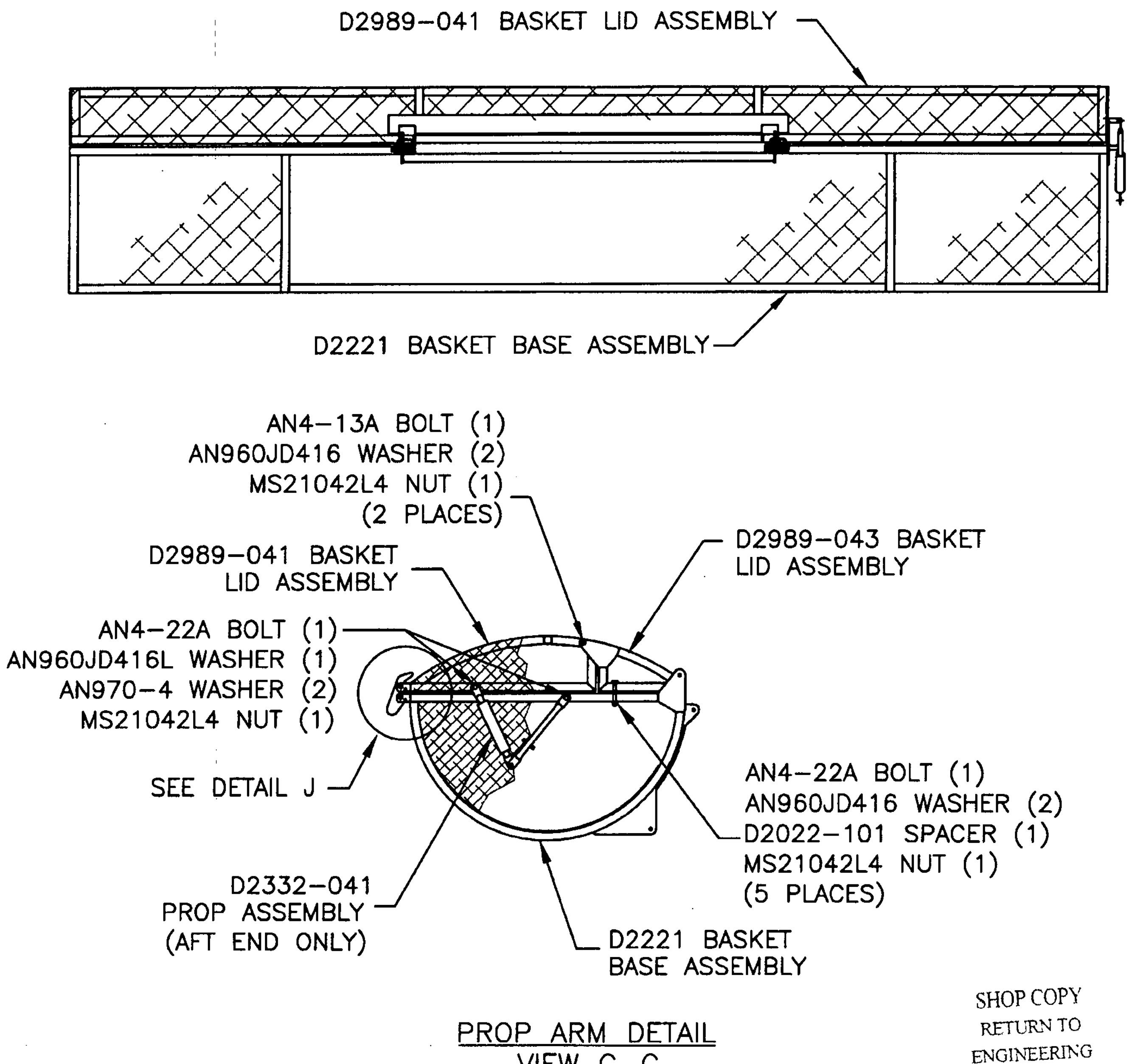
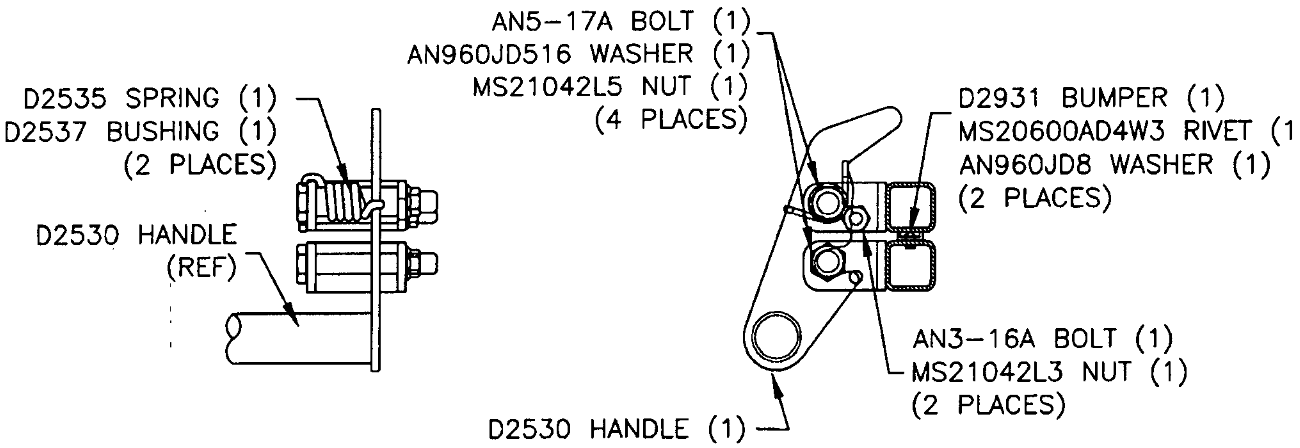


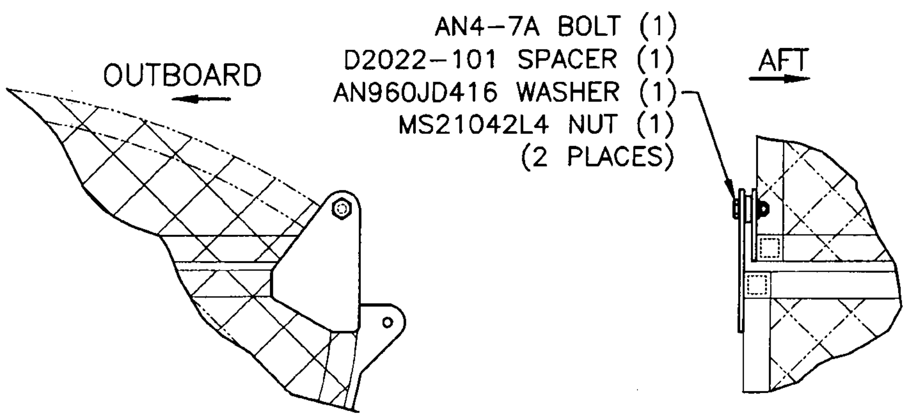
Figure 5– Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)



SPRING DETAIL

LATCH DETAIL

DETAIL J:
HANDLE WELDMENT



HINGE DETAIL
END VIEW, LOOKING AFT
OTHER END OPPOSITE

HINGE DETAIL
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

DETAIL H:
HINGE

Figure 6 – Basket Replacement Parts

13

Date: Wednesday, 3/7/2007 4:08:27 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 31087
Estimate Number : 10211
P.O. Number :
This Issue : 3/7/2007 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : LARGE FAB ASSY
Previous Run : 29129
Written By :
Checked & Approved By : 07.03.07
Comment : Est Rev:C as per DSI9318 06-01-24 JLM

Drawing Name : HELI UTILITY BASKET LH/RH 350/355
Part Number : D350607045
Drawing Number : D350-607 PG7-9
Project Number : N/A
Drawing Revision : F
Material :
Due Date : 3/30/2007 Qty: 1 Um: Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPPD350-607-045 CHG001	Has DSI 9273 Rev. B 07.06.06 ~~07.03.12~~
2.0	31087A	350 BASKET BASE (SHORT)
	Comment: Sub-Component 350 BASKET BASE (SHORT) D3265-041 B________	
3.0	31087B	350 BASKET LID (SHORT)
	Comment: Sub-Component 350 BASKET LID (SHORT) D3266-041 B________	
4.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick: Assemby Kit	
5.0	D2022101	Spacer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assemby Kit Qty Part Number Description Batch 2 D2022-101 Spacer ________	

REFERENCE ONLY

Form: mprocess

Date: Wednesday, 3/7/2007 4:08:44 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 BASKET BASE (SHORT)
Job Number	: 31087A		
Estimate Number	: 10209		
P.O. Number	: N/A	Part Number	: D3265041
This Issue	: 3/7/2007 S.O. No. : N/A	Drawing Number	: D3265 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 30859A	Material	: N/A
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.03.07		
Comment	: Est Rev.C Re-Format 05-11-03 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Qty 3 D3166-1 Basket Hoop Batch: B32067 — 07/08/28

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 19.2150 f(s)/Unit Total : 19.2150 f(s)
3/4" x 3/4" x 0.063" wall 304/316 SS tubing.
(M304TS0.750W.065)
Batch: M104980 — 07/08/28

3.0	D22323	Basket Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	B31784

07/08/28

4.0	D2325	Support Gusset (350 Bask

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	B32571

07/08/28

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________________ **PAR #:** _______ **Fault Category:** ___________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:08:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 31087A
Part Number: D3265041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D23273	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	B30876

AA 07/08/28

Seq. #:	Machine Or Operation:	Description :
6.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B32066

AA 07/08/28

Seq. #:	Machine Or Operation:	Description :
7.0	D34425	Shim

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3442-5	Shim	B24846

AA 07/08/28

Seq. #:	Machine Or Operation:	Description :
8.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 26.0000 sf(s)/Unit Total : 26.0000 sf(s)
Pick:

Qty	Part Number	Description	Batch
26sf	M304EX0.75-16F	Expanded Metal	M104905

AA 07/08/30

Seq. #:	Machine Or Operation:	Description :
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-CUT (3) D2235-1 FROM D3166-1

2-Drill hole in D3265-3 as per Dwg D3265

3-Remove all markings from material

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

AA 07/08/31

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes (No) **DQA:** D **Date:** 07/08/14

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Wednesday, 3/7/2007 4:08:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 31087A

Part Number: D3265041

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	PD 08-04-07
11.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	PD 08-04-07
12.0	POWDER COATING	POWDER COATING
	M 105068	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 BR	07-09-04
13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Seal support gusset seam with White Sikaflex-291 Batch: M104732 Expiry date: 10/2007	SAD 07/09/06
14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		07/09/06
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
15.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:______	
16.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07/09/11

Job Completion

07-09-11

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3265 REV. B SHEET 1 OF 3
DATE 05.06.08		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS

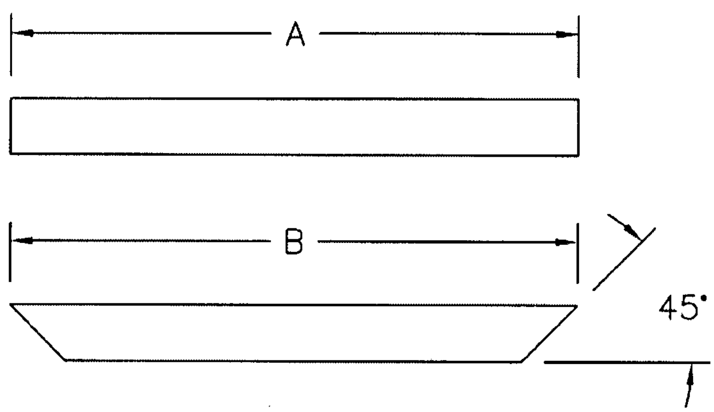
DART

A	04.02.02	NEW ISSUE
B	05.06.08	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

RELEASED 05.08.19

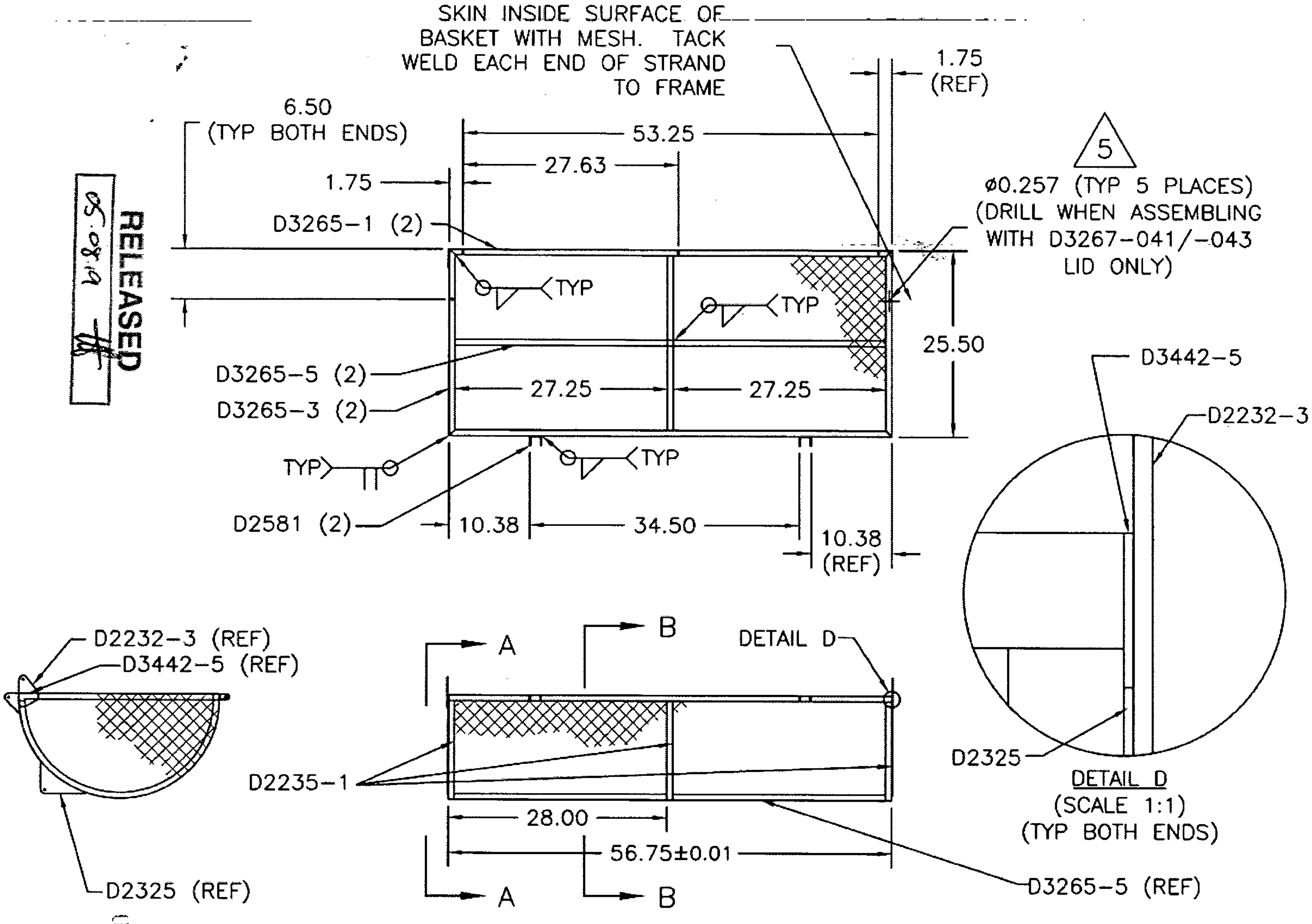
PARTS LIST FOR D3265-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3265-1	2	———	56.75	RIB
D3265-3	2	———	25.50	RIB
D3265-5	2	27.25	———	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-5	2	N/A	N/A	SHIM



D3265-1/-3/-5

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D3265-041 BASE WITH D3267-041/-043 LID



RELEASED 05.08.19

D3265-041 BASKET BASE ASSEMBLY

1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
2) WELD PER DART QSI 004
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

DESIGN	DRAWN BY
DS	PH
CHECKED	APPROVED
DATE	
05.06.08	

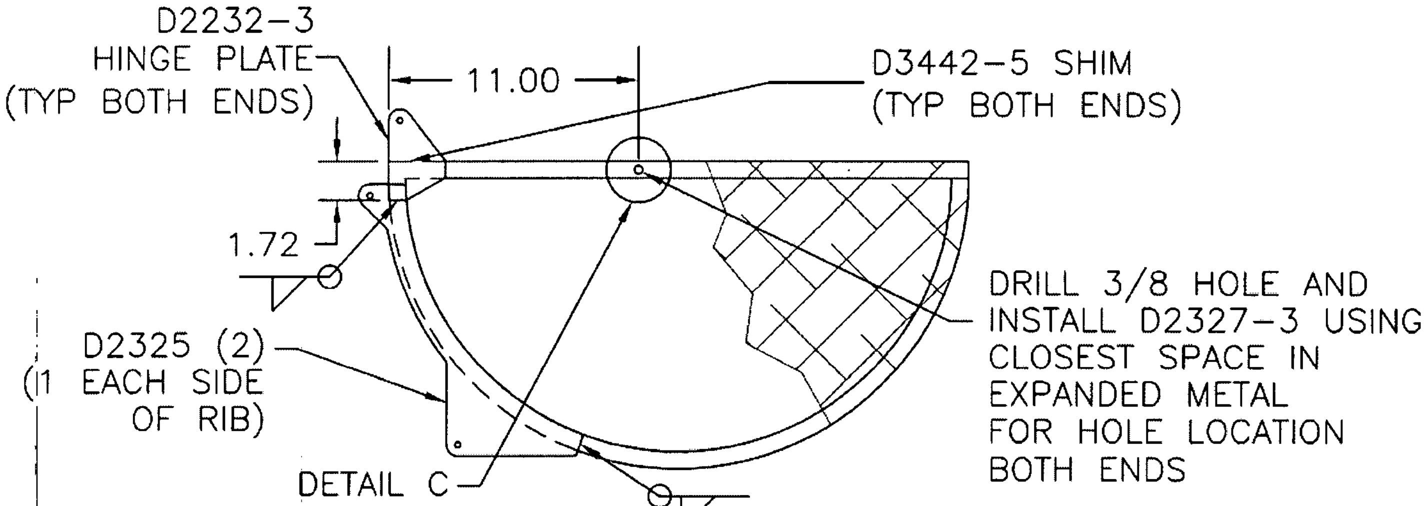
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3265 — REV. B — SHEET 2 OF 3

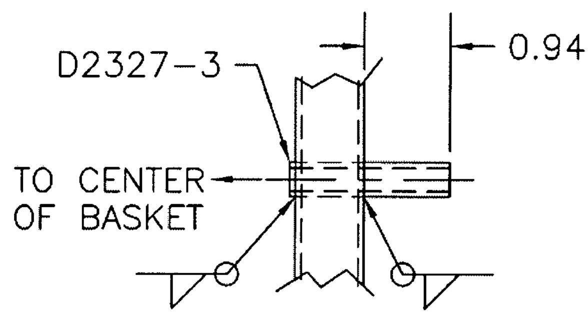
TITLE: BASKET BASE ASSEMBLY (350) — SCALE 1:20

DART

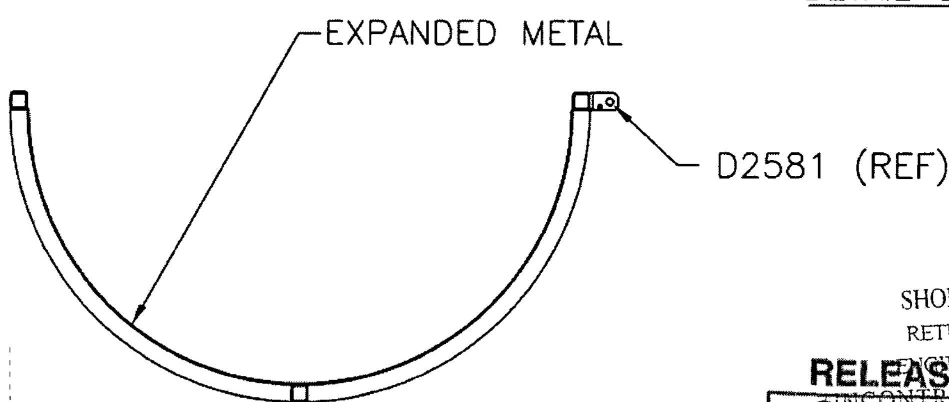
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. D3265 — REV. B — SHEET 3 OF 3
DATE 05.06.08		TITLE: BASKET BASE ASSEMBLY (350) — SCALE 1:8



SECTION A-A SAME BOTH END RIBS



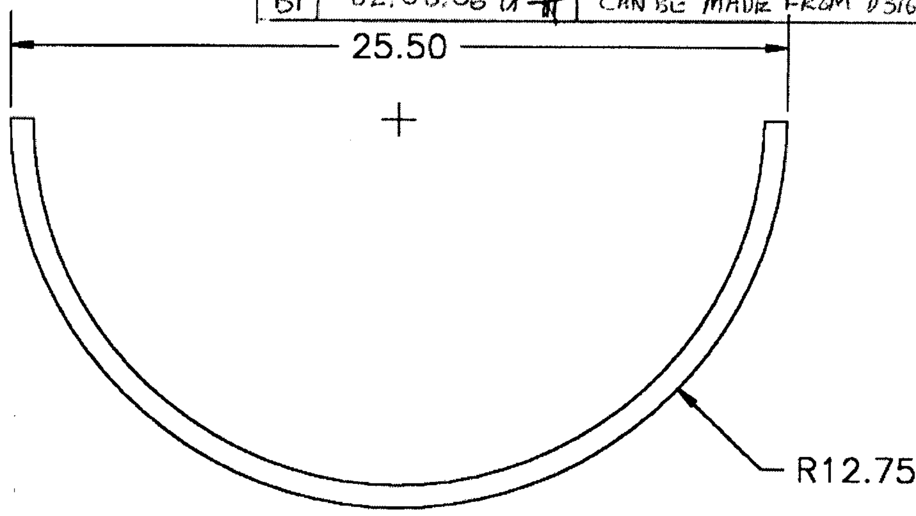
DETAIL C



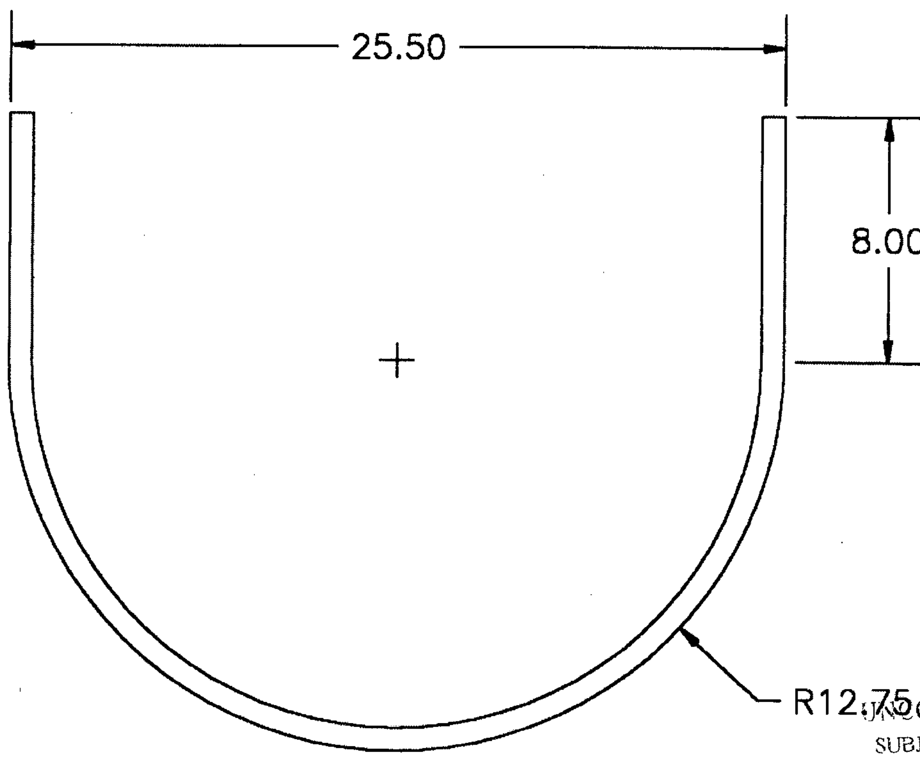
SECTION B-B SAME BOTH CENTER RIBS

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
B WILLIAMS	B WILLIAMS	
CHECKED	APPROVED	DRAWING NO. D2235 — REV. B — SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS — SCALE
B1	02.08.06	CAN BE MADE FROM D3166-1



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 (B1)

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

Date: Wednesday, 3/7/2007 4:08:58 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 BASKET LID (SHORT)
Job Number	: 31087B		
Estimate Number	: 10210		
P.O. Number	: N/A	Part Number	: D3266041
This Issue	: 3/7/2007 S.O. No. : N/A	Drawing Number	: D3266-041 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A1
Previous Run	: 29129B	Material	: N/A
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.03.07		
Comment	: Est Rev:B Re-Format 05-11-03 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31663	Basket Hoop

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty 1 D3166-3 Basket Hoop Batch: B33682 07/08/28

Seq. #:	Machine Or Operation:	Description :
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 28.3500 f(s)/Unit Total : 28.3500 f(s)
3/4" x 3/4" square tubing as per Dwg D3266Material: 304/316 SS tube .063" wall(
M304TS0.750W.065)
Batch: M104980 07/08/28

Seq. #:	Machine Or Operation:	Description :
3.0	D22321	Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-1	Hinge plate	B31608

07/08/28

Seq. #:	Machine Or Operation:	Description :
4.0	D23271	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-1	Bushing	B31693

07/08/28

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:08:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** 350 BASKET LID (SHORT)

Job Number: 31087B | **Part Number:** D3266041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D2506	Placard

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2506	Label Plate	B31786

AJ 07/08/28

Seq. #:	Machine Or Operation:	Description :
6.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B32066

AJ 07/08/28

Seq. #:	Machine Or Operation:	Description :
7.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 10.0000 sf(s)/Unit Total : 10.0000 sf(s)
Pick:

Qty	Part Number	Description	Batch
10sf	M304EX0.75-16F	Expanded Metal	M104905

AJ 07/08/30

Seq. #:	Machine Or Operation:	Description :
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236 From D3166-3

2-Cut 3/4" x 3/4" square tubing as per Dwg D3266

3-Drill holes in D3266-1 as per Dwg D3266 using Drill Jig DT8305

4-Deburr & Remove all markings from material

5-Weld as per Dwg D3266 using Welding Table and corner Jig Deburr as required

AJ 07/08/31

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/09/11

QA: N/C Closed: ______ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:08:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET LID (SHORT)

Job Number: 31087B

Part Number: D3266041

Job Number:

Seq. #:	Machine Or Operation:	Description :
9.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	PD 08-04-07 (1)
10.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	PD 08-04-07 (1)
11.0	POWDER COATING	POWDER COATING
	M 105068	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 BR	07-09-04 (1)
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Wing Walk Batch: M 105386 and Spray Paint black Batch: M 104941 as per Dwg D3266and QSI 005 4.4	BR 07-09-04 (1)
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: Inspect Powder Coat and Wing Walk	SAD 07/09/05 (1)
14.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(1) [illegible] 07/09/11

Job Completion

U 07.09.11

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** ______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

QA COPY ISSUED

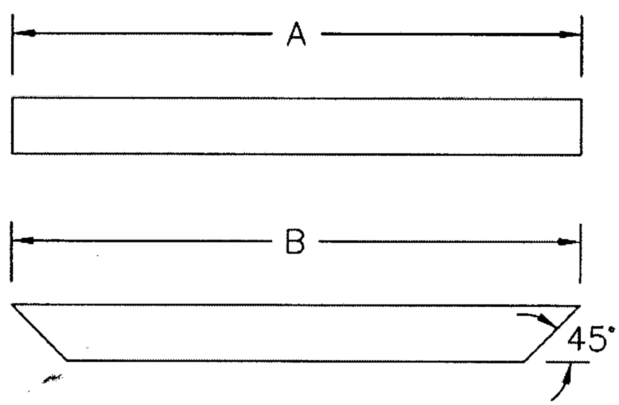
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3266 — REV. A — SHEET 1 OF 4
DATE 04.02.02		TITLE BASKET LID ASSEMBLY (350) — SCALE NTS

REV		DATE	DESCRIPTION
A		04.02.02	NEW ISSUE
A1		04.09.20	TACK WELD ANTI-SKID AREA

RELEASED 04.02.10

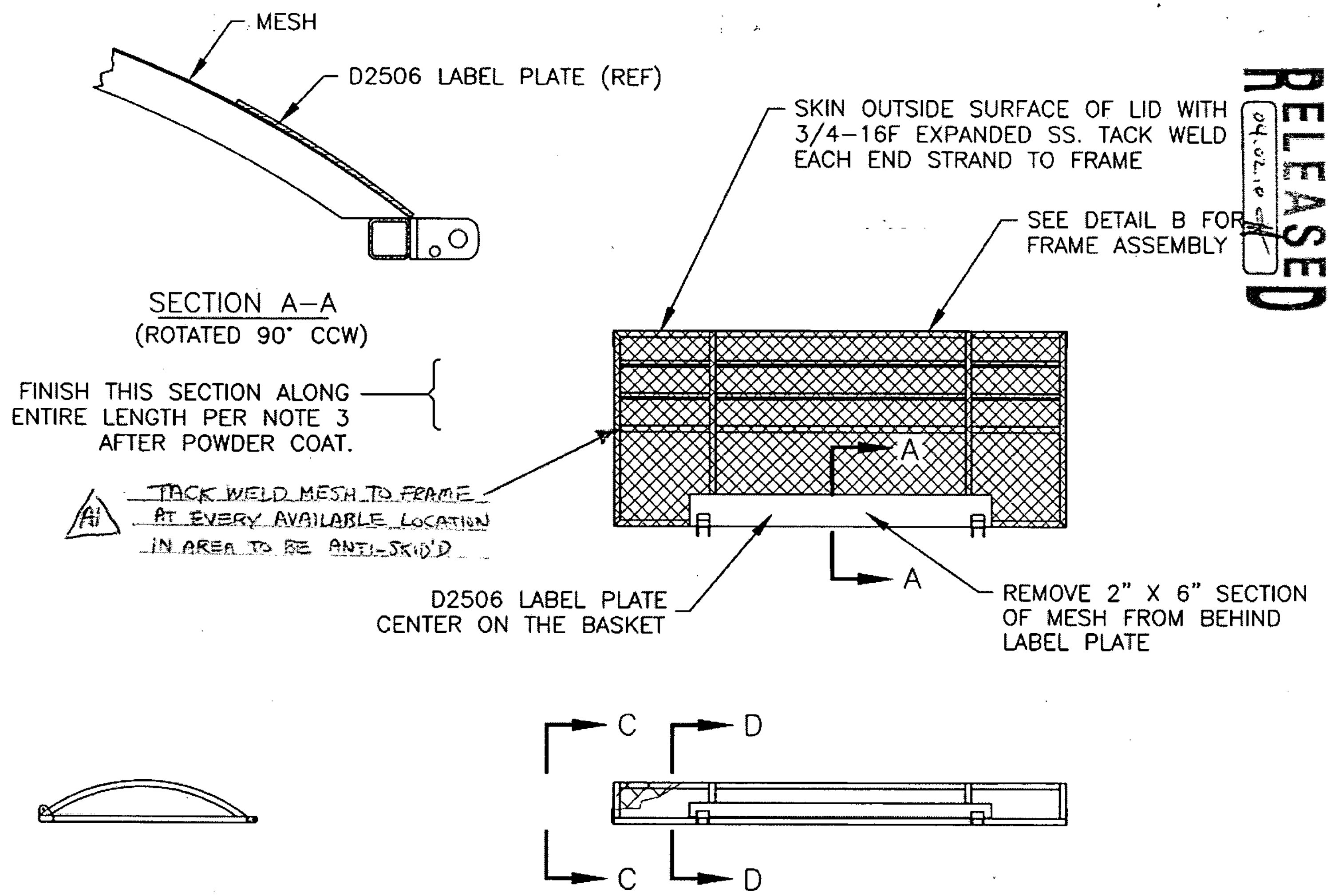
PARTS LIST FOR D3266-041 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3266-1	2	——	25.50	RIB
D3266-3	2	——	56.17	RIB
D3266-5	6	11.27	——	RIB
D3266-7	3	30.63	——	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D3266-1/-3/-5/-7

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES



D3266-041 BASKET LID ASSEMBLY

1) MESH MATERIAL: 3/4-16F EXPANDED SS
2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) SPRAY PAINT BLACK INSIDE SURFACE
   APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 31087B

RELEASED 04.02.10

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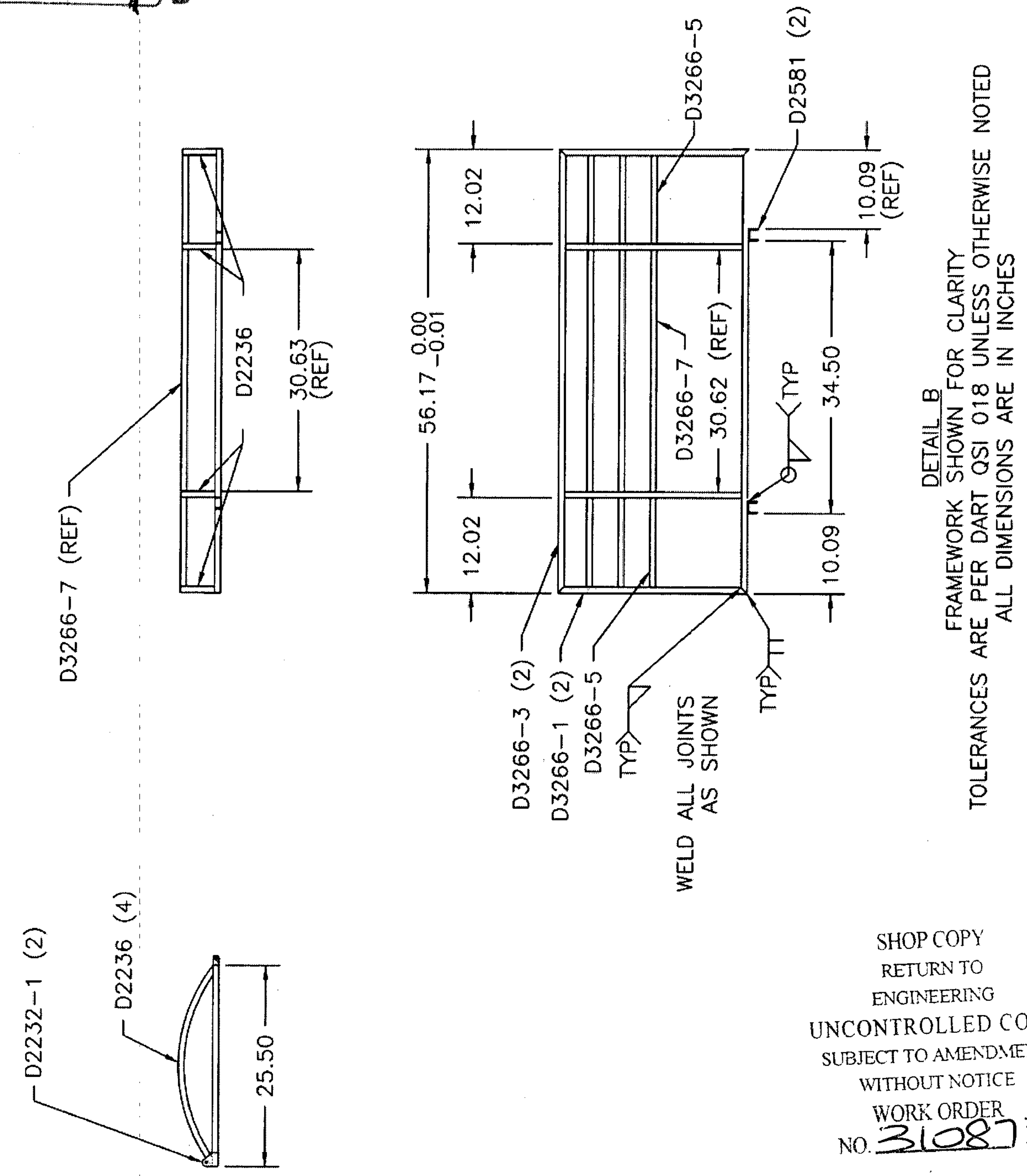
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3266 — REV. A — SHEET 2 OF 4
DATE 04.02.02		TITLE BASKET LID ASSEMBLY (350) — SCALE 1:20

DART

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3266 — REV. A — SHEET 3 OF 4
DATE 04.02.02		TITLE BASKET LID ASSEMBLY (350) — SCALE 1:20

RELEASED 04.02.10



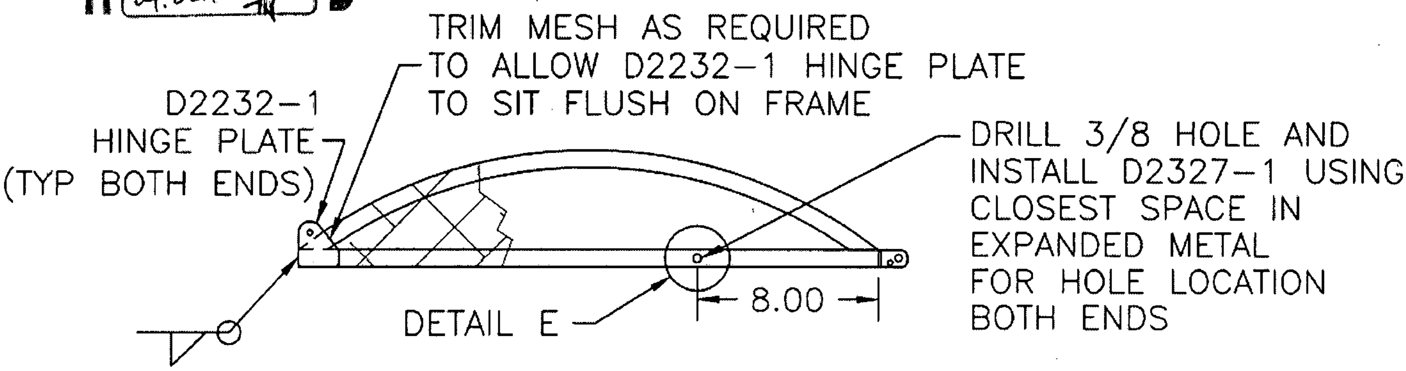
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WORK ORDER NO. 31087B

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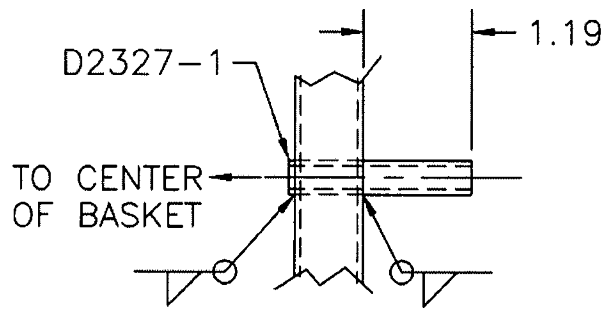
QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3266 — REV. A — SHEET 4 OF 4
DATE 04.02.02		TITLE BASKET LID ASSEMBLY (350) — SCALE 1:8

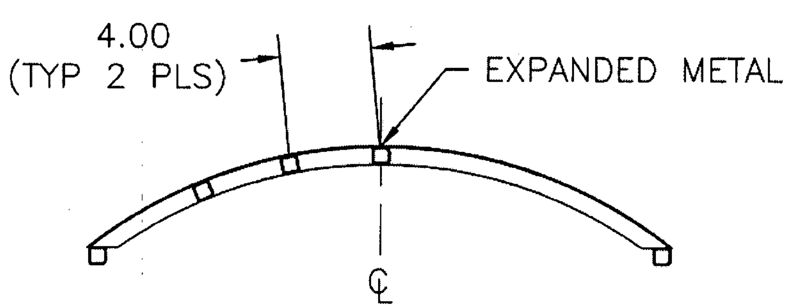
RELEASED 04.02.10



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

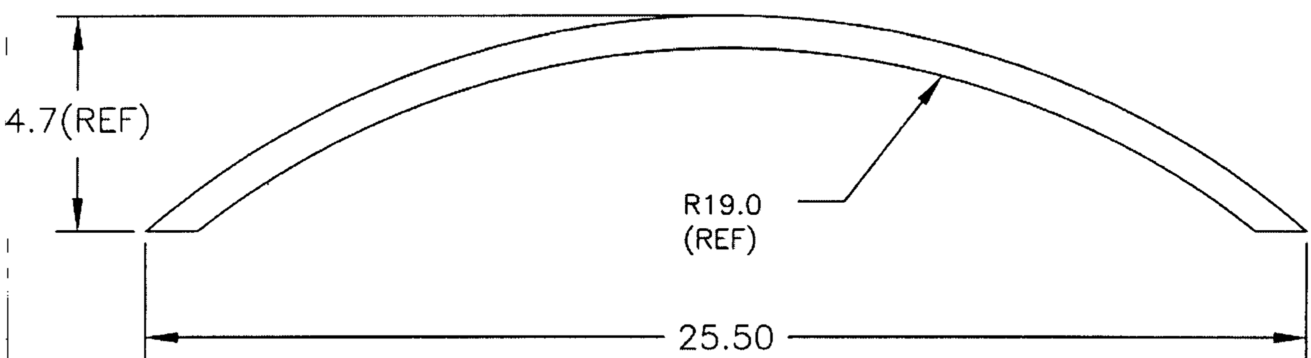
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WORK ORDER NO. 31087B

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	PH	
CHECKED	APPROVED	DRAWING NO. D2236 REV. C SHEET 1 OF 1
DATE 05.06.07		TITLE LID RIB SCALE 1:4

A	94.05.30	NEW ISSUE
B	94.12.16	LID
C	05.06.07	UPDATE NOTES,CHANGE RADIUS TO 19.0

RELEASED 05.08.19



D2236

D2236 LID RIB
1) MAKE FROM D3166-3 BASKET HOOP
2) FINISH: NONE
3) ALL DIMENSIONS ARE IN INCHES
4) ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31087B

Dart Aerospace Ltd.

Date: Thursday, 06/12/2007 11:02:02 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	**Drawing Name**	: D350-607/D130-701
Job Number	: 36168		
Estimate Number	: 10804		
P.O. Number	: N/A	**Part Number**	: Z_CUSTOM
This Issue	: 06/12/2007 **S.O. No.** : N/A	**Drawing Number**	: ECN 1082
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: N/A
Previous Run	: 00015	**Material**	: N/A
Written By	:	**Due Date**	: 13/12/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

REMOVE FROM STK:

D130-701-041 ~~31938~~ 34534 34227 32299 35345

34531 D350-607-041 33228 - 33724 - 34278 - 35525 - 35526 35105 -

35347 D350-607-043 34279 - 35346

D350-607-045 31773 - 31086 - 31087 - 35904

D350-607-047

ADD NEW PAPERWORK TO KITS IN STOCK
EASA STC, PER ECN 1082 7/12/07 SD (19X)

RETURN TO STOCK

2.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 07/12/11

Job Completion 07.12.11

Form: rprocess

Dart Aerospace Ltd.

Date: Tuesday, 20/11/2007 12:42:02 PM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	**Drawing Name**	: D350-607
Job Number	: 35902		
Estimate Number	: 10804		
P.O. Number	: N/A	**Part Number**	: Z_CUSTOM
This Issue	: 20/11/2007 **S.O. No.** : N/A	**Drawing Number**	: ECN 1068
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: N/A
Previous Run	: 00015	**Material**	: N/A
Written By	:	**Due Date**	: 20/11/2007 **Qty:** ~~18~~ 15 **Um:** Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
PULL FROM STK:

D350-607-041/42 ch006 (35347) (35537) (32263) (35105) (34277) (34534) (32290) (33228) (33727) (34278)

D350-607-043/44 ch003 (34280) (34299) (35346) 3

ch001 D350-607-045 (31088) (31087)

D350-607-047 ~~31951 #41~~

ADD DSI9380-011 KITS TO EACH KIT
CHANGE WHITE LABEL TO NEW CHG NUMBER
D350-607-041 - CHG 007
D350-607-043 - CHG 004
D350-607-045 - CHG 002
D350-607-047 - CHG 002

7-11-20
(15x)

RETURN TO STK

ADD NEW RED DECAL TO KIT AND DSI PAPERWORK

2.0	DSI9380011	RUBBER CUSHION KIT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s)
RUBBER CUSHION KIT B35501 7/11/20 (18)

Form: rprocess

Date: Tuesday, 20/11/2007 12:42:02 PM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	**Drawing Name**	: D350-607
Job Number	: 35902		
Estimate Number	: 10804		
P.O. Number	: N/A	**Part Number**	: Z_CUSTOM
This Issue	: 20/11/2007 **S.O. No.** : N/A	**Drawing Number**	: ECN 1068
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: N/A
Previous Run	: 00015	**Material**	: N/A
Written By	:	**Due Date**	: 20/11/2007 **Qty:** ~~18~~ 15 **Um:** Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
PULL FROM STK:

D350-607-041/42 ch006 (35345) (35537) (32263) (35105) (34277) (34534) (32290) (33228) (33727) (34278)

D350-607-043/44 ch003 (34282) (34299) (35346) 3

ch001 D350-607-045 (31088) (31087)

D350-607-047 ~~3451 H4~~

ADD DSI9380-011 KITS TO EACH KIT
CHANGE WHITE LABEL TO NEW CHG NUMBER
D350-607-041 - CHG 007
D350-607-043 - CHG 004
D350-607-045 - CHG 002
D350-607-047 - CHG 002

7-11-20
(15x)

RETURN TO STK

ADD NEW RED DECAL TO KIT AND DSI PAPERWORK

Seq. #:	Machine Or Operation:	Description :
2.0	DSI9380011	RUBBER CUSHION KIT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s)
RUBBER CUSHION KIT B35501 7/11/20 (18)

Form: rprocess